: CROSSBOLT SPACER

, Date: User: Tuesday, 07/04/2009 10:18:34 AM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 46956

Estimate Number

: 10993

P.O. Number

This Issue

: 07/04/2009 Prsht Rev.

: NC

First Issue **Previous Run** : //

: 46434

Written By

Comment

Checked & Approved By

: Est E 02.06.17 est

Type

07.07.06

rev E dwg

: MACHINED PARTS

Drawing Number Project Number

Drawing Name

Part Number

. D2579 REV E : N/A

: E **Drawing Revision**

Material **Due Date**

: 22/04/2009

: D2579

Qty:

200 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 6061-T6 RD Tube .500 x.058W

1.0

M6061T6T0500W058

Comment: Qty.:

0.3762 f(s)/Unit Total: 75.2430 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch <u>4110335</u> HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio 4245

3.0

2.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

5.0

SECOND CHECK



Comment: SECOND CHECK **PACKAGING 1**

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stoo Location: DAL

Dart Aeros	pace	Ltd
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W/O: WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHAI	IGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Appi QC Ins	roval spector
									r rod wigi		
								_			
D4 N-											
Part No		PAR #:									
	Re		Disposition:								
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORDE	R NON-CONFORM	ANCE (NCR)					
DATE	STEP	EP Description of NC	Corrective Action Section B			Verificatio		cation	n Approval	App	roval
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		ion C	Chief Eng	QC Inspe	
					:						
								-			
NOTE: D	ate & initia	al all entries								$ldsymbol{ldsymbol{ldsymbol{eta}}}$	

Date:

Tuesday, 07/04/2009 10:18:34 AM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 46956

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.04.14

Dart Ae			WC	ORK ORDER CHANGES	<u> </u>					+-
DATE	STEP	PR	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Appi QC Ins	
AND THE STREET										
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :		Date:		
Resolution:		Disposition	QA: N/C Closed:			Date:				
NCR:				ER NON-CONFORMAN						
DATE	OTE D	Description of NC	Corrective Action S		Section B		lion	A		
DATE	DATE STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign &	Verificat Section		Approval Chief Eng	App QC In	
			Offici Eng	Office Eng	Date				11	
			Office Eng	Office Eng	Date					
			Official	Office Eng	Date					
			Official	Citiel Eng	Date					
			Official Eng	Citiel Eng	Date					
			Official Eng	Citiel Elig	Date					
			Official English	Citiel Elig	Date					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41956
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	First Arti	cle	Prot	otvne	
				otype	
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+/-0.030	4.074				
+/-0.010	.659				
			!		
				-	
					<u>. </u>
			_		
					<u> </u>
					<u>.</u>
	+/-0.010	+/-0.030	+/-0.030	+/-0.030	+/-0.030

Measured by:	Audited by: 13.A	Prototype Approval:	N/A
Date: 09/04/12	Date: 09/04/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	07.09.06	Dwg Rev updated	KJ/JLM	臣



DESIG	-##	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED IL	APPROVED	DRAWING NO. REV. E
	一	M	D2579 SHEET 1 OF 1
DATE			TITLE SCALE
07.	04.17		CROSS BOLT SPACER 1:1
Α		96.09.16	NEW ISSUE
В		96.12.05	0.065 WALL WAS 0.035 WALL
С		97.02.21	0.058 WALL WAS 0.065 WALL
D		99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)
Ε		07.04.17	UPDATE NOTES



	4.070±0.030
Ø0.500 Ø0.384 (REF)	
0.058	

D2579 CROSS BOLT SPACER

D2579 CROSS BOLT SPACER

MATERIAL:

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8

(REF_DART_SPEC_M6061T6T0500W058)

2) FINISH: NONE

SHOP COPY **RETURN TO**

3) ALL DIMENSIONS ARE IN INCHES

ENGINEERING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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